

CCR(SPL)

CHARACTERISTICS AND APPLICATIONS :

CCR(SPL) is a semi-basic super heavy coated hardfacing electrode producing a high carbon, high chromium and nickel alloy weld deposit. The weld metal is extremely hard at room temperature and retains its hardness up to 550°C. The weld metal has excellent resistance to high temperature abrasion. Typical applications include hardfacing of blast furnace bells, hoppers, parts in coke chutes, coal handling equipments, etc.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL :

| | | | | | |
|---------|-------|-----|------|------|-----|
| Element | : C | Mn | Si | Cr | Ni |
| Percent | : 3.0 | 1.0 | 0.60 | 29.0 | 4.0 |

WELD METAL HARDNESS :

At room temperature : 48-54 RC

At 500°C: 40-44 RC

CURRENT AND PACKING DATA : AC / DC(+)

| | | | |
|---------------|-----------|---------|----------|
| Size (mm) | : 5x350 | 4x350 | 3.15x350 |
| Dia x Length | | | |
| Current Range | : 200-240 | 160-180 | 120-140 |
| (Amps) | | | |
| Weight/Carton | : 2.5 | 2.5 | 2.5 |
| (kgs) | | | |

PRECAUTIONS:

1. Ensure the electrodes are dry. Rebake the moist electrodes at 250°C for one hour.
2. Do not use excess current.